

Work Order ID 68500

Thursday, April 14, 2011 10:16:13 AM



Page 1

Item ID: D4055-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Front and Bottom

Start Date: 4/14/2011 Start Qty: 2.00

Required Date: 4/27/2011 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/04/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4055	A								
100		0.00							
Purchasing		0.00							
Purchasing	Memo								
	Issue P/O: <u>13870</u>								
	Purchase part as per Dwg D4055								
	Possible Supplier: GFI								
	Material release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging		0.00							
Packaging	Memo								
120	QC6- Inspect dimensions to drawing	0.00							
QC		0.00							
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68500

Thursday, April 14, 2011 10:16:13 AM



Page 2

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Setup Start



Revision ID:

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Item Name: Tank Front and Bottom

Start Date: 4/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

3 BR 11-5-17

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3 φ 11-5-17

150

Identify as per dwg & Stock Location: 117

0.00



Packaging

Memo

0.00

Packaging

11-05-17 3 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68500

Page 3

Thursday, April 14, 2011 10:16:13 AM

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Item Name: Tank Front and Bottom

Start Date: 4/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/18
WF
11-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

-NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:16:10 AM

Page 1

Work Order ID: 68500



Parent Item: D4055-11



Parent Item Name: Tank Front and Bottom



Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-11P  Tank Front and Bottom		Purchased	No			110	Each	0.0000	 1	1			

Pupps/13 (3)

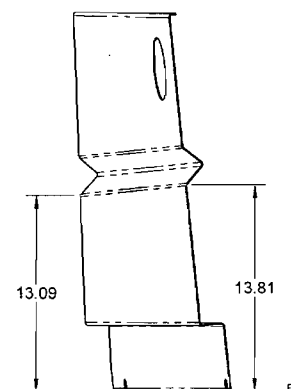
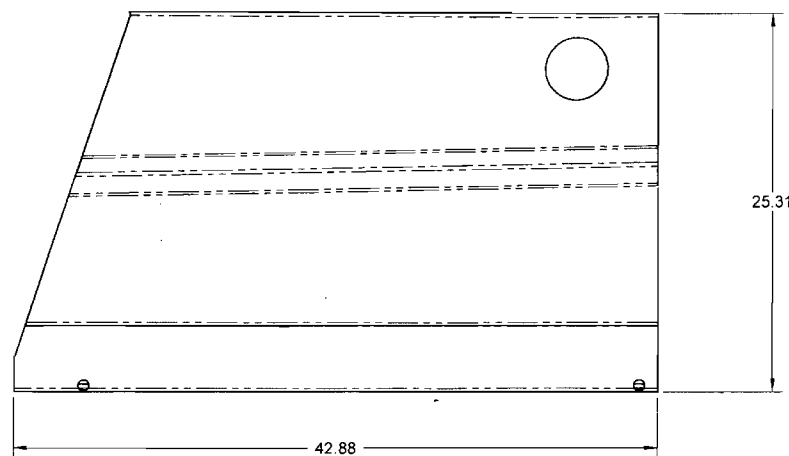
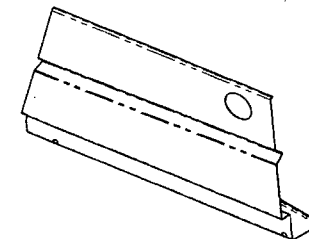
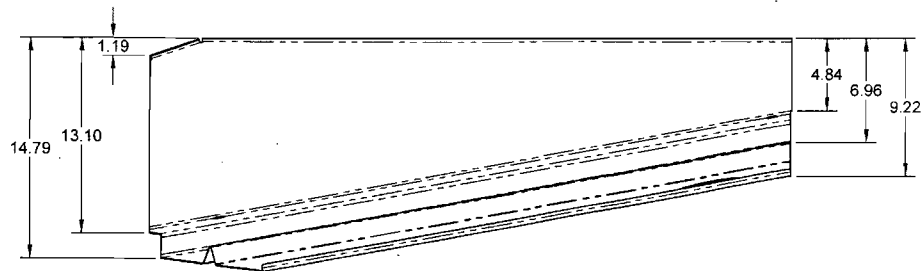
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



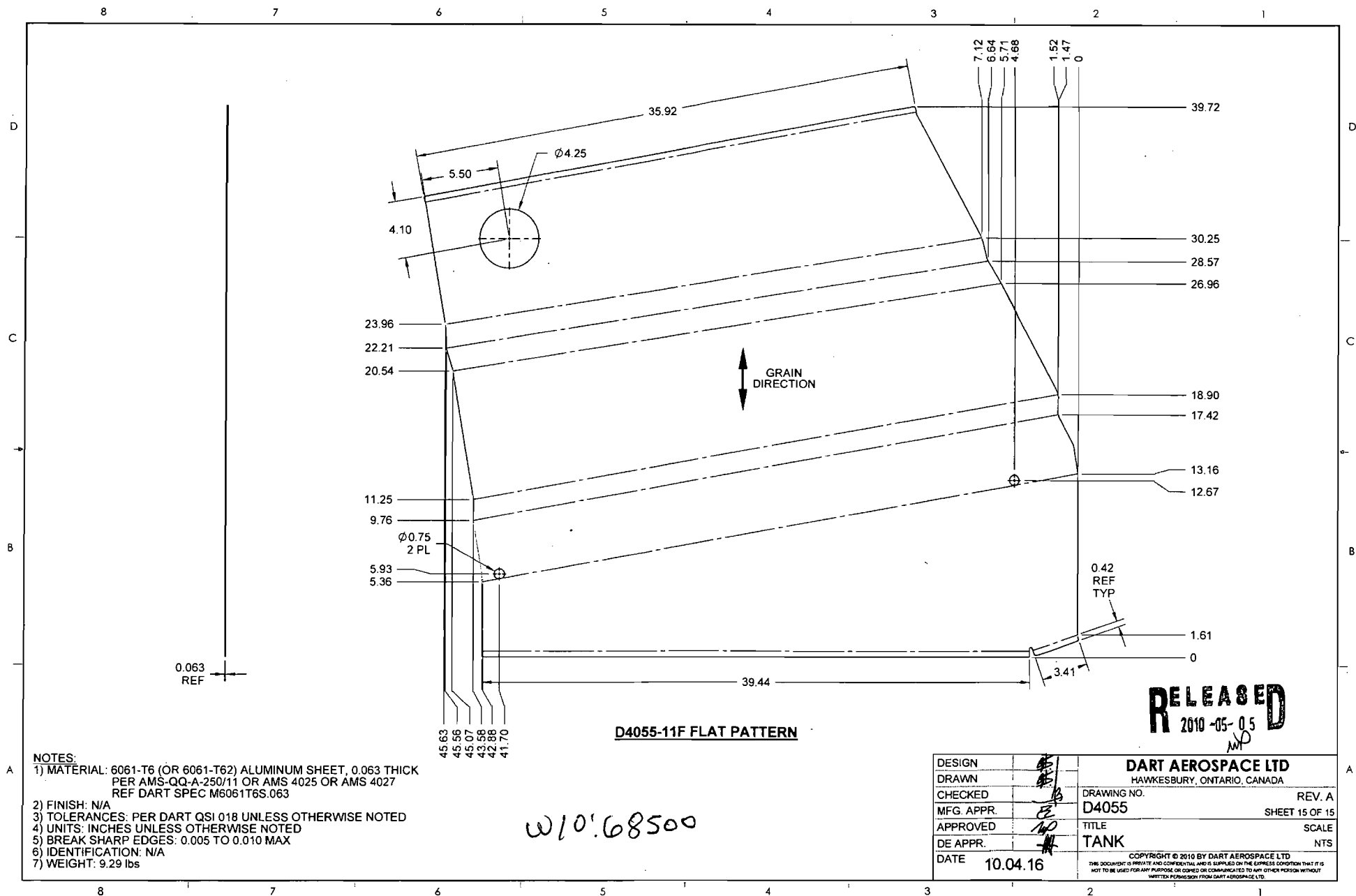
D4055-11 TANK FRONT AND BOTTOM







CL 11104114
W10'68500

- NOTES:
- 1) MATERIAL: MADE FROM D4055-11F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.29 lbs

RELEASED
2010-05-05
JMS

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4055	REV. A
MFG. APPR.			SHEET 14 OF 15
APPROVED		TITLE TANK	SCALE
DE APPR.			NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 15 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO1070

Purchase Order Date 4/14/2011

PO Print Date 4/14/2011

Page Number 1 of 1

Order From :

VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Contact Name

Vendor Phone 514 630 4877

Vendor Fax 514 630 4849

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4055-11P	Tank Front and Bottom	5/5/2011 Yes	3.00 Each	FedEx Overnight	\$115.0000	\$345.00
		Special Inst:	As per DWG: D4055 Rev: A B68500				

PO Total: \$345.00

Change Nbr: 2

Change Date: 4/14/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

I est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO	PAGE
JR - DY	MO - MO	AN - YR		
12	05	11	0461893	1/1



NDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
--------------------------------	------------------------	--	------------------------

DART GFI-0299 0230615 PO13870

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO	DESCRIPTION
---------------------	-----------------------	-------------

3 D4055-11P

TANK FRONT AND BOTTOM

CERTIFICATE OF CONFORMANCE REQ

MFG. JOB# J0230615-001 QTY 3 pcs



EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

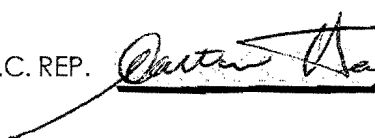
CERTIFICATE NO. 4 OUR JOB NO J0230615 SHIPPING MEMO 0461893

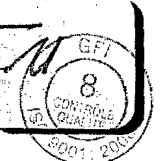
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	<u>3 PCS</u>	<u>PO13870</u>	<u>D4055-11P</u>	<u>A</u>	<u>TANK FRONT AND BOTTOM</u>	<u>A</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>.063 THK AL 6061-T6 (AMS-QQ-A250/11)</u>		<u>SAMUEL / ALCOA INC</u>		<u>116412</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>N/A</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0230615-001 (3 PCS)</u>		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 12 MAY 2011

G.F.I. Q.C. REP. 



**LES MÉTAUX
SPÉCIALISÉS**
SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2008 + AS9100B

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: APRIL 21, 2011

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire Qc
Zip Code: H9R 1A1

du client: 0078394

de commande SSMQ: 332907

Customer's order #:

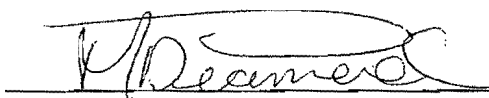
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	1	.063" X 48" X 144"	6061 T6	AMS-QQ-A-250/11 AMS 4027	116412

Bien à vous,
Yours truly,





8 11/05/10

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

1196245	0				
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item	Page
2011-01-03	5528224	00000	1000247864-4		1
P.O. No./Govt Contract No.	Customer	Alcoa Item			
C63071 Ln#: 1	SAMUEL SON & CO LT G041094947R05				

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3T5 QC

Item Description
0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -
.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED. AMS4027 REV N EXC_MRK
ASTMB209 REV 07 CMMP025 REV S ((MARKED))
KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-
20 % CQR 0210640 REV 05 CUST REQ 10-12-
28 *** W/E 11-01-08 ***

8 11/05/16

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	260783	116412	4055	100	PC	27714 46940 05097745
2	260785	116412	938	23	PC	27714 46940 05097749
3	260787	116412	4089	100	PC	27714 46940 05097750
			9082	223		

Notes for CQR: 0210640.5

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0210640.5 -Specification Limits

Temp	Dir	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T6	Long Transv.			42.0	35.0	10

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Lot: 116412	Min	0.40	0.15	0.8	0.04						REMAIN

- Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	Test	UTS KSI	TYS KSI	EL4D PCT
T6	Long Transv.	2		49.8	44.2	10.5



CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per

Malcolm Murphy

Director of Manufacturing Davenport Works

Kenton P. Young

Quality Assurance Manager

1196245

0

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

Page 2

2011-01-03

5528224

00000

1000247864-4

DCE-47864-4

P.O. No./Govt Contract No.

Customer

Alcoa Item

C63071 Ln#: 1

SAMUEL SON & CO LT G041094947R05

Lot: 116412 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
50 44.4 10.4

Cast Number Chemical - OES SI FE CU MN MG CR ZN TI
10R03563 Actuals 0.63 / 0.5 / 0.28 / 0.06 / 1.0 / 0.18 / 0.01 / 0.03

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States



